

ASAP for budget

Dart Aerospace Ltd.

Date: Tuesday, 7/1/2008 2:35:01 PM  
User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STRUT  
 Job Number : 40195  
 Estimate Number : 10219  
 P.O. Number :  
 This Issue : 7/1/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : / / Type : SMALL / MED FAB  
 Previous Run : 37849  
 Part Number : D219923  
 Drawing Number : D2199 REV. E1  
 Project Number : N/A  
 Drawing Revision : E1  
 Material :  
 Due Date : 7/15/2008 Qty: 6 Um: Each  
 Written By :  
 Checked & Approved By : 08.07.01  
 Comment : Est:D 02.06.10 Rem polish & add finish NG/CC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M304TR0750W049 304 RD Tube .750 x .049W



Comment: Qty.: 2.3100 f(s)/Unit Total: 11.5500 f(s) 15.000

Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall

(M304TR0750W049)

Batch No: M108498

SB 08/07/21 (6)

2.0 BRAKE NC NC BRAKE



Comment: BRAKE NC

Punch per Dwg D2199 and Spec Control Dwg D2638

SB 08/07/21 (6)

3.0 SMALL FAB 1 SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Debur

08/07/21 (6)

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/07/21 (6)

5.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

7:50 OF  
400  
8:20

Mid 08/07/22



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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Drawing Name: STRUT

Job Number: 40195

Part Number: D219923

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FD 08/07/22 (6)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

57247 PC 8/7/22 (6)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/22

Job Completion



MF 08-07-22



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

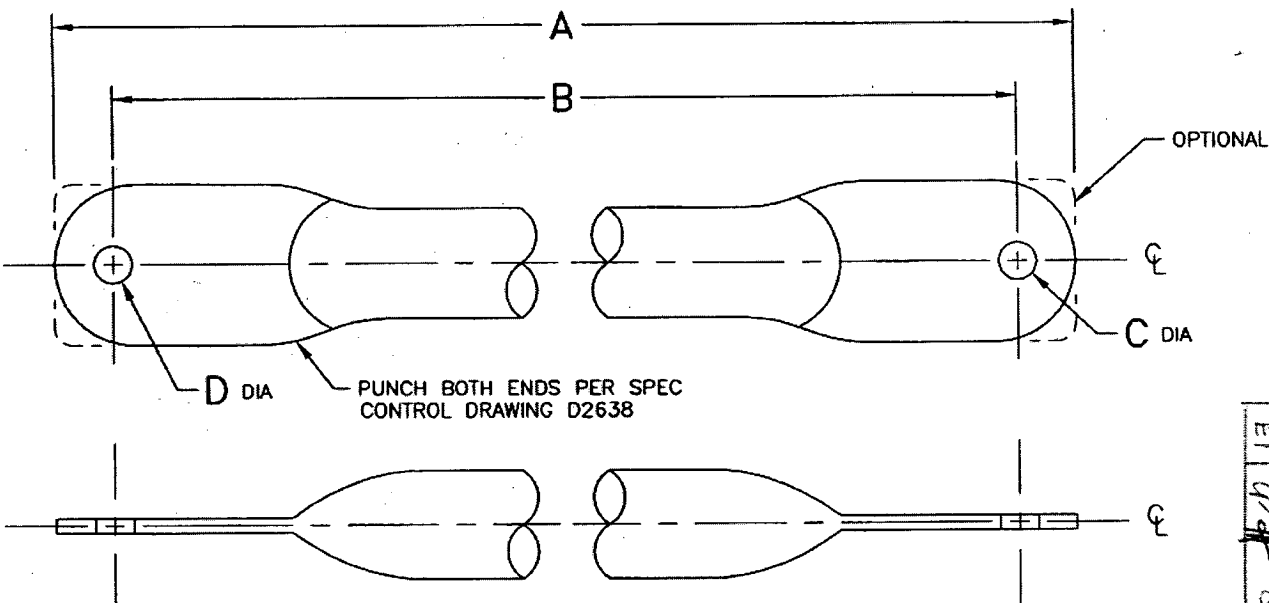




DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. E
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	
DATE	DRAWING NO.	D2199	SHEET 1 OF 1
98.04.28	TITLE	STRUT DETAILS	SCALE
			NTS

RELEASED  
48.05.05 KE

A	1993	NEW ISSUE
B		ADDED -11, -13, AND -15
C		ADDED -17 AND -19
D		ADDED -21
E	98.04.28	ADDED -23 AND -25 PER TSR A565M ADDED TEMPLATE & SPEC CTRL DWG REDRAWN IN CAD
E1	02.03.22	ADD FINISH



	A	B	C	D
D2199-1	18.30	17.50	0.257	0.257
D2199-3	5.80	5.00	0.257	0.257
D2199-5	22.64	21.84	0.257	0.316
D2199-7	14.74	13.94	0.257	0.257
D2199-9	16.52	15.72	0.257	0.257
D2199-11	23.60	22.80	0.257	0.316
D2199-13	15.96	15.16	0.257	0.257
D2199-15	17.57	16.77	0.257	0.257
D2199-17	28.05	27.25	0.257	0.316
D2199-19	18.90	18.10	0.257	0.257
D2199-21	10.80	10.00	0.257	0.257
D2199-23	26.18	25.38	0.257	0.316
D2199-25	19.93	19.13	0.257	0.257
D2199-27	27.34	26.54	0.257	0.316
D2199-29	21.11	20.31	0.257	0.257

BBBCCCEEE  
#00.10.13  
00.10.13

NOTES:

1. MAKE PER TEMPLATE DT2199-XX WHERE XX IS THE RESPECTIVE DASH NUMBER
2. MATERIAL: AISI 304/316 STAINLESS STEEL TUBE  $\phi 0.750 \times 0.049$  WALL
3. FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3/E1

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WITHOUT NOTICE  
WORK ORDER  
NO. 40145

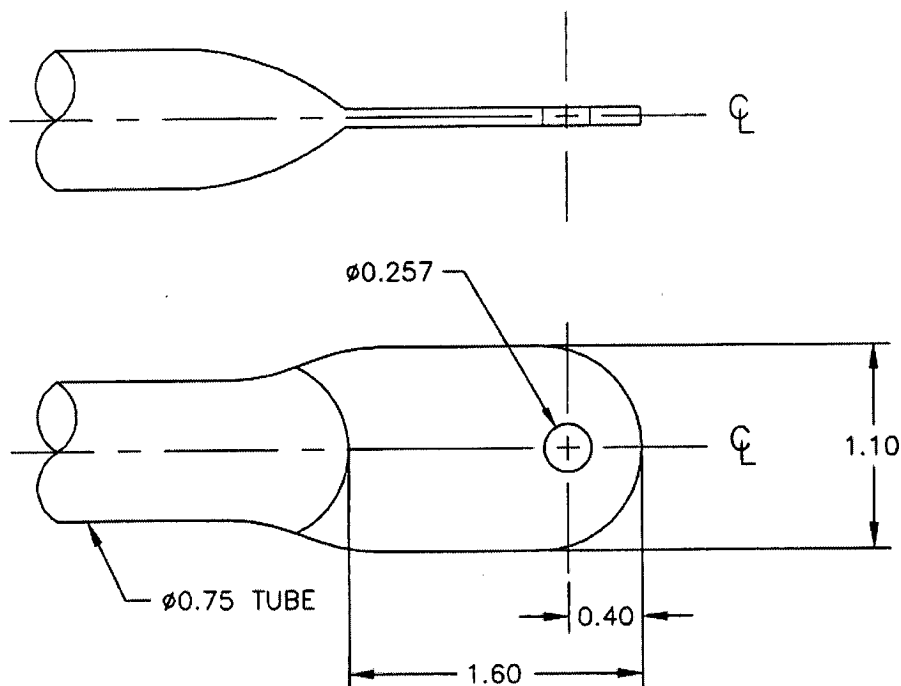




DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>ME</i>	APPROVED <i>KE</i>	DRAWING NO. D2638	REV. A SHEET 1 OF 1
DATE 98.04.28		TITLE PUNCH DT8117 SPEC CONTROL	SCALE 1:1
A	98.04.28	NEW ISSUE	

RELEASED  
98/04/05 KE

## SPECIFICATION CONTROL DRAWING FOR PUNCH DT8117



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